

SLUT

Date: Tuesday, 12/6/2005 11:13:37 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLADE FITTING
Job Number : 25111 -1	
Estimate Number : 10019	
P.O. Number : NIA	Part Number : D27421
This Issue : 12/6/2005 S.O. No. : NIA	Drawing Number : D2742 REV B1
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/6/2005 Type : MACHINED PARTS	Drawing Revision : B1
Previous Run : NIA	Material : NIA
Written By : SEE COMMENT BELOW	Due Date : 1/15/2006
Checked & Approved By : SEE ABOVE DATE & USER	Qty: 12 Um: 25 Each
Comment : Est Rev:H Removed P/O For Material 05-10-26 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6103001	7075-T651 3.25OD x 12.5L
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T651 3.25OD x 12.5L
(D6103-001 BLANK)
Batch : 25069 / 24640

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE
TURN AS PER FOLIO FA099 & DSK050
FOLIO REV: 378
DWG REV: Issue P.O. 378 to turn only per drawing

Receive + Inspect

C200101130

25

3.0	QC6	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC6

For 02-01-25

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
1-MACHINE AS PER FOLIO FA099 & DWG D2742
FOLIO REV: B
DWG REV: B
2-DEBURR & TUMBLE

Ep /

06/02/06

010

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D0742-1 PAR #: N/A Fault Category: Supplier/Metric NCR: Yes ☒ No ☒ DQA: 19 Date: 20/02/23
 QA: N/C Closed: 18 Date: 06.02.23

NCR: <u>25111</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>06/02/23</u>	<u>#4</u>	<u>one blade fitting has</u> <u>a dim of 0.972" instead</u> <u>on dim 1.000"</u> <u>Part Didnt sit properly in</u> <u>I.S.</u>		<u>the bearing is</u> <u>on the split</u> <u>2</u>				
<u>06/02/23</u>	<u>#20</u>	<u>one part scrap inside</u> <u>Base has 0.40" deep chatter</u> <u>marks done @ metric</u>	<u>18</u>	<u>scrap / destroy.</u> <u>Notify Metric of the</u> <u>chatter marks for possible</u> <u>credit.</u>	<u>En</u> <u>06/02/23</u>	<u>2</u> <u>06.02.23</u>	<u>18</u> <u>06.02.23</u>	<u>18</u> <u>06.02.23</u>

NOTE: Date & initial all entries

Date: Tuesday, 12/6/2005 11:13:37 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 25111

Part Number: D27421

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Ep 46 06/12/06

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1 a.m 06-02-20

2-Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3 G.m 06-02-22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MA 06 02 22

9.0

ALS41032225

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 ALS4-1032-225

Insert M14576

or AKS4-1032-225

or ALS7-1032-225

or AKS7-1032-225

a.m 06-02-22

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install ALS4-1032-225 Insert as per Dwg D2742

G.m 06-02-22

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MA 06 02 22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

DC

DOCUMENT CONTROL



(22)

Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/02/23

Job Completion



u 06.02.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

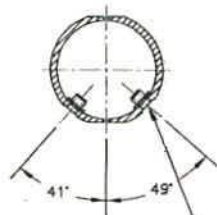
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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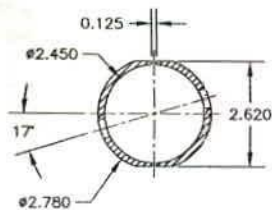
NOTE: Date & initial all entries

SECTION B-B



Ø0.297
C'BORE Ø0.430 x 0.045"
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)

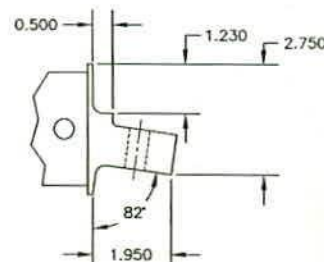
SECTION A-A



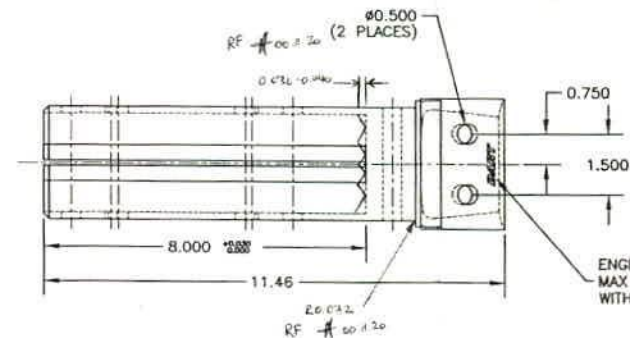
EFFECTIVE	DECs
9147	

GENERAL NOTES

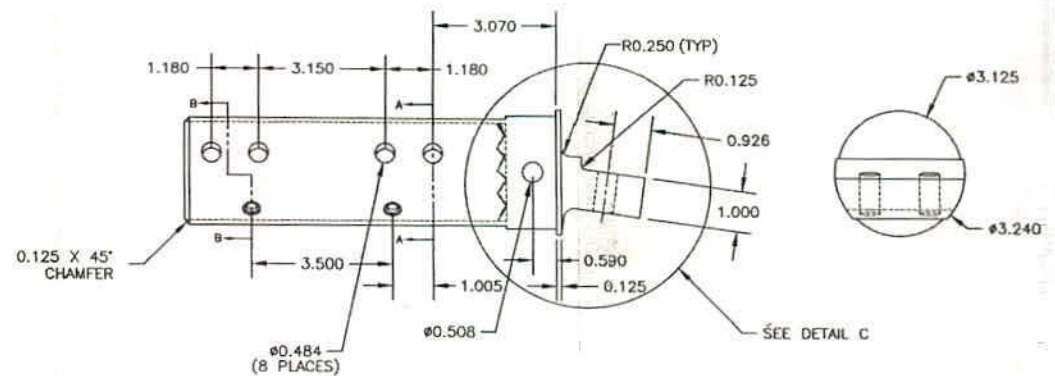
MATERIAL: 7075-T651 (QQ-A-200/11 OR QQ-A-225/9)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DETAIL C



ENGRAVE DART LOGO TO
MAX DEPTH OF 0.015
WITH MIN RAD 0.250



D2742-1 SHOWN (D2742-2 OPPOSITE)

RELEASED
98.11.03 DS



B	98.09.01	ADD INSERTS, AS MANUFACTURED
A	98.04.16	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, MA
CHECKED	APPROVED	DRAWING NO. D2742
DATE	TITLE	REV. B SHEET 1 OF 1 SCALE 1:3
98.09.01	BLADE FITTING	

DART AEROSPACE LTD		Work Order: 25111
Description: Blade Fitting		Part Number: D2742-1
Inspection Dwg: D2742 Rev: B1; DSK050 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
LATHE	8.000	+0.030/-0.000					
	9.250	+/-0.010					
	Ø3.240	+0.005/-0.000					
	Ø3.125	+0.005/-0.000					
	Ø2.780	+0.005/-0.000					
	Ø2.450	+0.005/-0.000					
	0.125 x 45°	+/-0.010					
	0.125	+/-0.010					
	12.50	+0.030/-0.000					
HAAS	0.100 x 0.135	N/A	N/A				
	0.500	+0.005/-0.000	0.500	-			
	1.500	+/-0.005	1.497	-			
	11.46	+/-0.030	11.462	-			
	1.180	+/-0.005	1.177	-			
	3.150	+/-0.005	3.146	-			
	3.500	+/-0.005	3.499				
	Ø0.484	+0.005/-0.000	0.480	-			
	Ø0.508	+0.005/-0.000	0.500	-			
	1.000	+/-0.010	1.006	-			
	0.926	+/-0.010	0.928	-			
	0.500	+/-0.010	0.510	-			
	1.230	+/-0.010	1.238	-			
	0.125	+/-0.010	0.125	-			
	2.620	+/-0.010	2.623	-			
	0.297	+0.005/-0.000	0.297	-			
	Ø0.430 x 0.045	+/-0.010	0.432 x 0.045	-			

Measured by: E
Date: 06/02/04

Audited by: MS
Date: 06/02/04

Prototype Approval: N/A
Date:

Rev	Date	Change	Revised by	Approved
A	03.12.12	New Issue	KJ/RF	

Linda Lacelle

From: Marcus Horner [MHORNER@metec.ca]
Sent: Monday, February 06, 2006 11:12 AM
To: Linda Lacelle
Subject: Re: BLADE FITTINGS

no problem, i did not see that one, i apologize
Marcus Horner
Production Manager
METEC Metal Technology Inc.
20 Terry Fox Drive, P.O Box 781
Vankleek Hill, Ontario K0B 1R0, Canada

Tel. (613) 678-3957

Fax (613) 678-3956

www.metec.ca

----- Original Message -----

From: "Linda Lacelle" <llacelle@dartaero.com>
To: "Marcus Horner (E-mail)" <MHORNER@metec.ca>
Sent: Monday, February 06, 2006 9:55 AM
Subject: BLADE FITTINGS

>
> We found one blade fitting that is scrap, it is chattered on the inside
> from
> the boring tool...will you just credit us?
> LL
>
>

I am using the free version of SPAMfighter for private users.
It has removed 753 spam emails to date.
Paying users do not have this message in their emails.
Try www.SPAMfighter.com for free now!